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D4610-3

Job Sheet 190350



Part No: D4610-3

Job Qty: 8 pcs

Part Name: Doubler



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/7/19

Job Tracking No:

Due Date: 3/11/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B SHEETS 2,3 IPP REV:A NEW ISSUE 12-03-22 JLM VERIFIED BY:EC IPP REV:B 12.04.20 as per dwg rev.B DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	8 pcs	3/11/19	3/11/19	0.00	0.17	Waterjet - Flow		De 19/03/04
110	QC 2	8 pcs	3/11/19	3/11/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		De 19/03/04
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		

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120	QC 8	8 pcs	3/11/19	0.00 0.00	QC 2 - 66	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	DAS
					QC 8 - 9	40
					QC 8 - 68	9-89
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
140	Small Fab - Brake NC - B4B	8 pcs	3/11/19	0.00 0.42	Small Fab - Brake - 1 - B4B	68-6
					Small Fab - Brake - 2 - B4B	03
					Small Fab - Brake - 3 - B4B	DAS
150	QC 5	8 pcs	3/11/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 42	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	DAS
					QC 5 - 9	40
					QC 5 - 50	9-89
					QC 5 - 30	
160	Handfinish - 1-1 Chemical-B4B	8 pcs	3/11/19	0.00 0.29	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	

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19/03/05

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170 QC 7	8 pcs	3/11/19	0.00 0.00	Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
				QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 6	
				QC 7 - 60	DAS
				QC 7 - 9	40
				QC 7 - 68	9-89
				QC 7 - 50	
				QC 7 - 67	
180 Packaging 3-1 - Stock - B4B	8 pcs	3/11/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	

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				Packaging 3 - 27 - B4B	ST104	MAR 06 2019
				Packaging 3 - 28 - B4B		
				Packaging 3 - 29 - B4B		
				Packaging 3 - 30 - B4B		
				Packaging 3 - 31 - B4B		
				Packaging 3 - 32 - B4B		
				Packaging 3 - 33 - B4B		
				Packaging 3 - 34 - B4B		
				Packaging 3 - 35 - B4B		
190 QC 21 - SA	8 pcs	3/11/19	0.00 0.00	QC 21 - SA - 21	DAS	21 MAR 06 2019
				QC 21 - SA - 70	9-25	
				QC 21 - SA - 53		

Part Op 100 - 1-Cut as per Dwg D4610 Dwg Rev: B Prog Rev: B 2-Deburr as required
 Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB
 120 - QC8- Inspect parts - second check
 140 - Bend as per dwg
 150 - QC5- Inspect part completeness to step on W/O
 160 - Chemical Conversion Coat per QSI005 4.1
 170 - QC7-Inspect Chemical Conversion Coat
 180 - Identify as per dwg & Stock Location: _____
 190 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.040	2024-T3 .040 Sheet	1.6000 sf (.2 ea)	100-Waterjet - Flow - 1	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M2024T3S.040	2	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Doubler	0.129Inches + 0.006 - 0.001	0.135 0.128	Diameter	
2	Doubler	3.650Inches ± 0.030	3.680 3.620		
3	Doubler	4.390Inches ± 0.030	4.420 4.360		
4	Doubler	0.909Inches ± 0.010	0.919 0.899		
5	Doubler	0.740Inches ± 0.030	0.770 0.710		
6	Doubler	1.285Inches ± 0.010	1.295 1.275	Diameter	
7	Doubler	1.500Inches ± 0.010	1.510 1.490	Diameter	
8	Doubler	1.960Inches ± 0.030	1.990 1.930		
9	Doubler	1.061Inches ± 0.010	1.071 1.051		
10	Doubler	2.160Inches ± 0.030	2.190 2.130		
11	Doubler	5.920Inches ± 0.030	5.950 5.890		
12	Doubler	1.640Inches ± 0.030	1.670 1.610		
13	Doubler	0.040Inches ± 0.010	0.050 0.030		

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

DART
AEROSPACE

Container No: S158711

Part: D461C-3

Job No: 190350

Serial No/Batch: S158711

Revision:

Inspector:

Exp. Date:

Instructions: Various STC's

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